Work Orde		60		*961	60*							Page 1	
Revision ID:	D3255-042			Accept	*N900	040	100)* s		Start	*N:	S1 *	
Item Name:	Access Panel A	ssembly								Stop	*N:	S2*	
Start Date:	1/21/13	Start Qty: 2.00	*2*		Cust Item	ID:							
Required Date: Reference:	2/08/13	Req'd Qty: 2.00	*2*		Customer:								
Approvals:	Process Plan	1: MLJ	Date: /3-01-24	Tooling:	D	ate:	· 	R		Start	*N	R1*	
			Date:)ate:				Stop	*N	R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revi	sion Nbr						· · · · · · · · · · · · · · · · · · ·					
D3255	Rev	В				•						/:	2-0
100				0.00									
1 <u>0</u> 0		Large Fab						2					•
Large Fab Large Fab		Memo 1-Weld as p Batch: <u>M∫</u>	er Dwg D3255 ***purge v 2-Grind W)								
110		QC10- Inspect visual pe	r QSI004- ground welds	0.00		•						2A Q \	
*11 0 *		Memo		0.00				_0	13	o-03	-05	(DAS	
Quality Control													
120		QC5- Inspect part comp	leteness to step on W/O	0.00								(DA)	•
120								(5	213	<i>-0</i> 3.	05	· v-89	
QC		Memo		0.00					_	-: •	•		

Quality Control

NICD.	Voc	1	NIA
NCR:	Yes	/	No

Date:

NCR: Y	es / N	כ			WORK ORDER NON-	CONF	FORN	AANCE / UPI	DATE	QA Closed:	Date:	
		· · · · · · · · · · · · · · · · · · ·			DISPOSITION				AGAINST DE		PROCESS	
Nork Orde	r:		······································		Rework	-		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0				Scrap	-		Machining Nachining	Small Fab	Pro	d. Eng. Coor.	Quality
raiciv	o				Use-as-is	┨ .		noforming	Finishing	∤	e/Packaging	Other
NCR N	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descr	I iption of work order update	Ini	itial	Act	tion	Sign &		
Cause	Dat	e Ste	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data												·
quip/Tooling											•	
perator			1		•							
//aterial	_											,
etup						1						
)ther	_		1									
rocess		1.										
upplier	_						:					
raining	_											
Inapproved				l		FAULT	CATE	GORY		1	<u> </u>	
Landir	ng Gear				General							
-	Bendi	ng		Г	Bend		Grain		Γ	Ovalized		Pressure/Forced
ed		Not Con	centric to	o/s	BOM/Route		lardwa	re		Over/Under	tolerance	Temperature/Cure
~g.	Crack				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
		ed/Crimpo	ed.		Burrs	-		ions Incomplete/	'Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs	,			Contamination		Mainte	enance		Part Moved		
	Heat	reat			Countersink		Mislabe	eled		Positioned \	Vrong	
ည	Inspe	tion Strip	in Tube		Cut Too Short		Misread	d .		Power Loss/	Surge	Other
	Ripple	s in Bend			Drill Holes		Offset					
	Torqu	e Waves i	n Extrusio	on [Drawing		Out of (Calibration		-		
	Turni	ng Sequen	ce		Finish		Out of S	Sequence				
	Wave/Twist in Tube				Folio		Outside Dimensions					

Work Orde January-23-13				*961	60*		Page 2			
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3255-042 Access Panel 1/21/132/08/13	Assembly Start Qty: 2.00 Req'd Qty: 2.00	*2*	Accept	Cust Item II	040100 D:)* Se	etup Start Stop	*NS1* *NS2*	
Reference:	. 2/00/13	Req u Qty. 2.00	*2*		Customer:			.		
Approvals:		nn:	Date:			nte:	R	un Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center I 130 *120* Powdercoat Powder Coating	D .	Operation Description Grey Sandtex (Ref. 4.3.5) Memo STARDYN	n⊘	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE:	Tool ID	Tool # Plan Code	Accept Qty	Qty 1	Reject Insp. Number Stamp	
¹⁴⁰ * 1∆∩ *		QC3- Inspect Part Finish		0.00		30			13/02/2	
QC Quality Control		Memo		0.00						

150

0.00

0.00

150 Small Fab

Small Fab

Small Fab

1-Bond D3255-5 gasaket to d3255-042 using Dow coming adhesive as per Dwg D3255A/R 736 DOW CORNING ADHESIVE Batch: 123 346

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UPDATE				
												QA Closed:	Date:	
Vork Ord	er:						DISPOSITION			AG	AINST DEI	PARTMENT	/PROCESS	
Part	•						Rework Scrap			⊢	sstube all Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR	No.						Use-as-is Work Order Update			~	nishing posite	Rec/Stor	re/Packaging Supplier	Other
Root					Des	cri	otion of work order update	1	nitial	Action	•	Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved														
							F.	AUL	T CATE	GORY				
Land	ng (Gear				_	General	_	1			٦		_
		Bending Centre No	ot Concer	ntric to	o/s		Bend BOM/Route		Grain Hardwa			Ovalized Over/Under) 	Pressure/Forced Temperature/Cure
	Cracks Broken/Damaged						_	-	1	on Incomplete		Part Incorre	⊢	Weld
	Crushed/Crimped. Burrs						ł	-	4	ions Incomplete/Unclear	-	Part Lost/Mi	issing	Wrong Stock Pulled
	<u> </u>	Cuffs				_	Contamination	\vdash	Mainte			Part Moved	• • • • • •	
	Heat Treat Countersink							\vdash	Mislabe		\vdash	Positioned V	_	Joshan
	Inspection Strip in Tube Cut Too Short						•	\vdash	Misread	1		Power Loss/	Surge	Other
	\vdash	Ripples in					Drill Holes	Offset						
	<u></u>	Torque W			n	<u> </u>	Drawing	<u> </u>	4	Calibration				
		Turning S	equence				Finish	1_	Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde January-23-13				*961				Page 3			
Item ID: Revision ID: Item Name:	D3255-042 Access Panel	Assembly		Accept	*N900	040	100)* s	etup Star Stop	171	S1* S2*
Start Date: Required Date: Reference:	1/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:					iV.	
Approvals:		an:				Oate:		R	tun Star Stop		R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control 170 *170* Packaging Packaging	D	Operation Description QC5- Inspect part compl Memo Identify as per dwg & St		Set Up/ Run Hours 0.00 3.2 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject	Insp. Stamp
180 *180* QC Quality Control		QC21- Final Inspection • Memo	- Work Order Release	0.00					MUS	5 13 M	-07-20 F 3-2-29

NICD.	V	1	B1 -
NCR:	Yes	/	No

DQA: ____ Date: _

NCR:	⁄es	/ No				WORK ORDER NON-	CON	FORM	MANCE / UP	DATE					
		_									QA Closed:	Date:			
Nork Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
Part f	۱o.					Rework Scrap		ſ	Skić-tube Machining	Crosstube Small Fab	-{	Water Jet	Engineering Quality Other		
NCR f	No.					Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root			!		Descri	iption of work order update	Ir	nitial	Ac	ction	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector		
oc/Data						·						4			
quip/Tooling									-						
perator											,				
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etup			1					ひら	*						
ther									,						
rocess															
upplier															
raining												_	,		
Inapproved					•		<u> </u>					<u>'</u>			
							FAUL1	CATE	GORY						
Landi	ng (3				General					.				
	_	Bending			. _	Bend		Grain		<u> </u>	Ovalized	_	Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s _	BOM/Route	\vdash	Hardwa		ļ	Over/Under		Temperature/Cure		
	L	Cracks			<u> </u>	Broken/Damaged	\vdash	•	ion Incomplete	_	Part Incorre		Weld		
	_	Crushed/	Crimped.		<u> </u>	Burrs	-		ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	<u> </u>	Cuffs			<u></u>	Contamination	\vdash		enarice	-	Part Moved	,			
Heat Treat Countersink						-	Mislabe		<u> </u>	Positioned V		٦			
Inspection Strip in Tube Cut Too						Cut Too Short	Ш	Misread	t		Power Loss/	Surge	Other		
		Ripples in	Bend			Drill Holes		Offset							
		Torque W	/aves in E	Extrusio	n	Drawing			Calibration						
		Turning S	equence			Finish	- 1		Sequence						
		Wave/Tw	ist in Tul	oe	i	Folio		Outside Dimensions							

January-23-13 11:49:15 AM

Work Order ID:

96160

Parent Item:

D3255-042

Parent Item Name:

Access Panel Assembly

Start Date: 1/21/13

Required Date: 2/08/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2 Panel		Manufactured	No	94696	<u> </u>	100	Each	0.0000	1	2			/3~0
D3255-3 Cap		Manufactured	No			150	Each	12.0000	1	2		******	/3~0
				Location		Loc Qty	<u>Lo</u>	c Code					
				WA001		2						•	
				759	69	2							
				WA002		10			 				
				832 861	- The state of the	2 8			(<u>'</u> _2				
D3255-5 Gasket	•	Manufactured	No	•		100	Each	8.0000	1	2		12/-	3/01
				Location		Loc Qty	<u>Lo</u>	c Code			XI	136	75/01
				GA		8							
				721	18	1							
				750		i							
				923		2			_				
				945	17	4							

		,	
NCR:	Yes	/	No

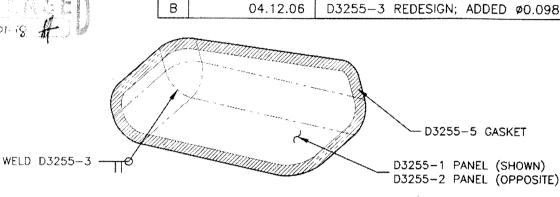
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

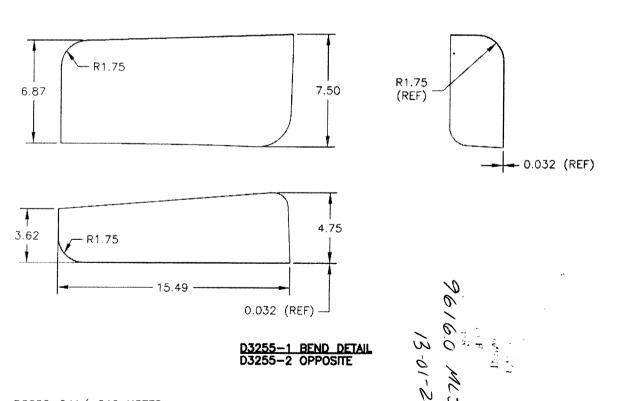
NCR: Y	es / No				WORK ORDER NON-C				QA Closed:	Date	e:
Work Orde	·r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Prod	Water Jet	Engineering Quality
raiciv					Use-as-is	The	moforming	Finishing	1	e/Packaging	Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desci	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling							-				
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved							<u> </u>				
						AULT CAT	EGORY				
Landir	ng Gear			_	General			[1 .	г	_
	Bending			<u></u>	Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardy		<u> </u>	Over/Under	ŀ	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	├ ── │ `	ction Incomplete		Part Incorre	ŀ	Weld
	Crushed/	Crimped	-		Burrs	—	ictions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
ļ	Cuffs				Contamination	—	tenarice		Part Moved		,
	Heat Trea				Countersink	\vdash	beled	<u> </u>	Positioned \	· ·	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre			Power Loss/	Surge	Other
	Ripples ir				Drill Holes	Offse					
	Torque V	Vaves in I	Extrusio	n L	Drawing	\vdash	f Calibration				
	Turning S	Sequence	!	L	Finish		f Sequence				
	Wave/Tw	vist in Tul	be		Folio	Outsi	de Dimensions				



DESIG	N P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHEC	KED /O	APPROVED	DRAWING NO.	REV. B
	41	- H	D3255	SHEET 1 OF 4
DATE	***************************************	***************************************	TITLE	SCALE
04.1	2.06		ACCESS PANEL ASSEMBLY	1:6
Α		04.01.27	NEW ISSUE	
!			 	



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



D3255-041/-042 NOTES: 1) WELD PER DART QSI 004

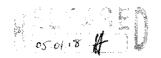
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255—5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

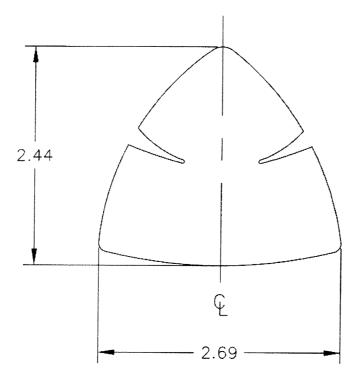
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CHECKED (APPROVED	D3255	REV. B SHEET 2 OF 4	
DATE		TITLE	SCALE	1
04.12.06		TITLE	1:1	





D3255-3 CAP FORM TO FIT D3155-1/-2

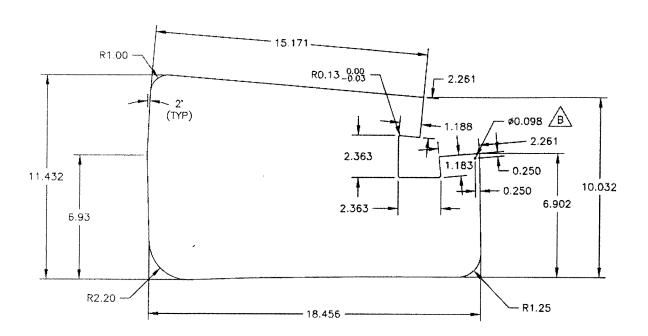
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



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CHECKED (APPROVED	DRAWING NO.	REV. B SHEET 3 OF 4
DATE	17	TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





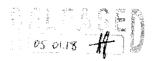
D3255-1/-2 FLAT PATTERN

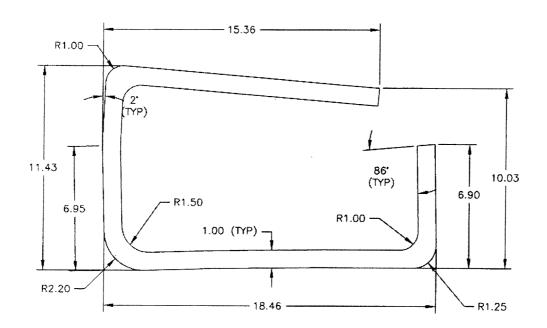
D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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CHECKED	APPROVED	DRAWING NO.	REV. B
4	1	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

- D3255-5 NOTES:
 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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